



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4004-041
Job Sheet 187219



Part No: D4004-041

Job Qty: 2 ea

Part Name: Side Restraint Angle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/29/18

Job Tracking No:

Due Date: 12/13/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B SHEETS 1,3,4 IPP rev A 09.12.15 new issue Prelim EC verified by:DD IPP Rev:B 10.05.17 as per ECN10-562 DD verf: IPP Rev:C 12.03.07 as per dwg rev.b DD verf: EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	2 pcs	12/13/18	12/13/18	0.00	0.37	Waterjet - Flow		SC 12/13/18
110	QC	2 pcs	12/13/18	12/13/18	0.00	0.00	QC2 Waterjet-3		SC 12/13/18
120	QC	2 pcs	12/13/18	12/13/18	0.00	0.00	QC8-4		DEC 21 2018
130	Brake NC	2 pcs	12/13/18	12/13/18	0.10	0.20	Brake NC 2		DAS 12/13/18
140	QC	2 pcs	12/13/18	12/13/18	0.00	0.00	QC5		FEB 11 2019
150	HandFinish	2 pcs	12/13/18	12/13/18	0.00	0.18	HandFinish1		DR 1/16/19
155	QC	2 pcs	12/13/18	12/13/18	0.00	0.00	QC7-3		DR 1/16/19
160	Powdercoat	2 pcs	12/13/18	12/13/18	0.00	0.12	Powdercoat9		DR 1/16/19
170	QC	2 pcs	12/13/18	12/13/18	0.00	0.00	QC3		DAS 36
180	Small Fab	2 pcs	12/13/18	12/13/18	0.00	0.69	Small Fab-5		DAS 36
190	QC	2 pcs	12/13/18	12/13/18	0.00	0.00	QC5		MAR 20 2019
200	Packaging	2 pcs	12/13/18	12/13/18	0.00	0.00	Packaging3-2	5+242	ST MAR 21 2019
210	QC21-SA	2 Ea	12/13/18	12/13/18	0.00	0.00	QC21		DAS 36

M/2287 START: 11:00 OUT: 320° FINISH: 11:30 MAR 21 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	.4400 sf (.22 ea)	100-Waterjet - Flow - 1	5629837
D4004-3	Strut Lock Bracket	2 Ea (1 ea)	180-Small Fab	5138921
D4004-7	Hose Clip	2 Ea (1 ea)	180-Small Fab	5099416
MS20426AD4-4	Rivet	2 Ea (1 ea)	180-Small Fab	5113854-1
MS20426AD4-5	Rivet	4 Ea (2 ea)	180-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.063	0	95	0
180-Small Fab	D4004-3	2	1	0
	D4004-7	2	7	0
	MS20426AD4-4	2	2,961	0
	MS20426AD4-5	4	1,646	0

Part Specifications



DART
AEROSPACE

Route update only

7

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev J

Specifications could not be found.

Plex 11/29/18 8:09 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order: 187219
Description: Side Restraint		Part Number: D4004-1
Inspection Dwg: D4004 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.098	/		ISC-01	
Ø0.129	+0.005/-0.001	0.130	/		ISC-02	
3.65	+/-0.030	3.654	/			
0.223	+/-0.010	0.225	/			
10.63	+/-0.030	10.634	/			
2.99	+/-0.030	2.993	/			
5.79	+/-0.030	5.799	/			
0.87	+/-0.030	0.871	/			
2.40	+/-0.030	2.401	/			
1.38	+/-0.030	1.372	/			
0.50	+/-0.030	0.507	/			
0.79	+/-0.030	0.794	/			
0.38	+/-0.030	0.386	/			
0.98	+/-0.030	0.982	/			
1.18	+/-0.030	1.184	/			
1.56	+/-0.030	1.566	/			
0.063	+/-0.010	0.060	/			

Measured by: SC	Audited by: DAS 68	Preliminary Approval:
Date: 18/12/19	Date: 9-89	Date:

Rev	Date	Change	Revised by	Approved
A	10.08.03	New Issue P/O D4004-041	KJ	
B	13.02.27	Dwg Rev updated	KJ	

Dart Aerospace Ltd.
1270 Abchurch Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S138942



Part: D4004-041

Job No: 187219

Serial No/Batch: S138942

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/19/18